

Work Order ID 87587

87587

Page 1

July-23-12 10:49:34 AM

Item ID: D3913-7

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib

Start Date: 7/24/12

Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/07/24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	<u>1B</u>								
100	<u>OFB 12/07/26</u>	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1- Cut tube as per dwg D3913 2- remove identification marks and deburr								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

12 SAD 12.08.24

12 12.8.24

DAS
24
9-83

12 12.8.24

DAS
24
9-83

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Work Order ID 87587***87587***

Page 2

July-23-12 10:49:34 AM

Item ID: D3913-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib

Start Date: 7/24/12

Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MUT 12108124

ME.
12-08-24

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION <div style="display: flex; justify-content: space-around;"> <div style="text-align: right;"> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> </div> <div style="text-align: right;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div style="text-align: right;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div style="text-align: right;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div style="text-align: right;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>								
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Doc/Data												
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Picklist Print

July-23-12 10:49:33 AM

Page 1

Work Order ID: 87587

Parent Item: D3913-7

Parent Item Name: Rib

Start Date: 7/24/12

Required Date: 8/10/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
DD verf:EC

IPP Rev:B 11.01.17 chg qc5 to 6

Component Item ID/ item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049 Square Tubing		Purchased	No			100	f	1,059.1670	1.594	6.7115788			

540 12-08-24

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT018	644	
122413	644	
MAT034	415.1669523	
118460	0.00001534	
121328	2.059994	
121565	20.775743	
121808	392.3312	

20.1348

NCR: Yes / No

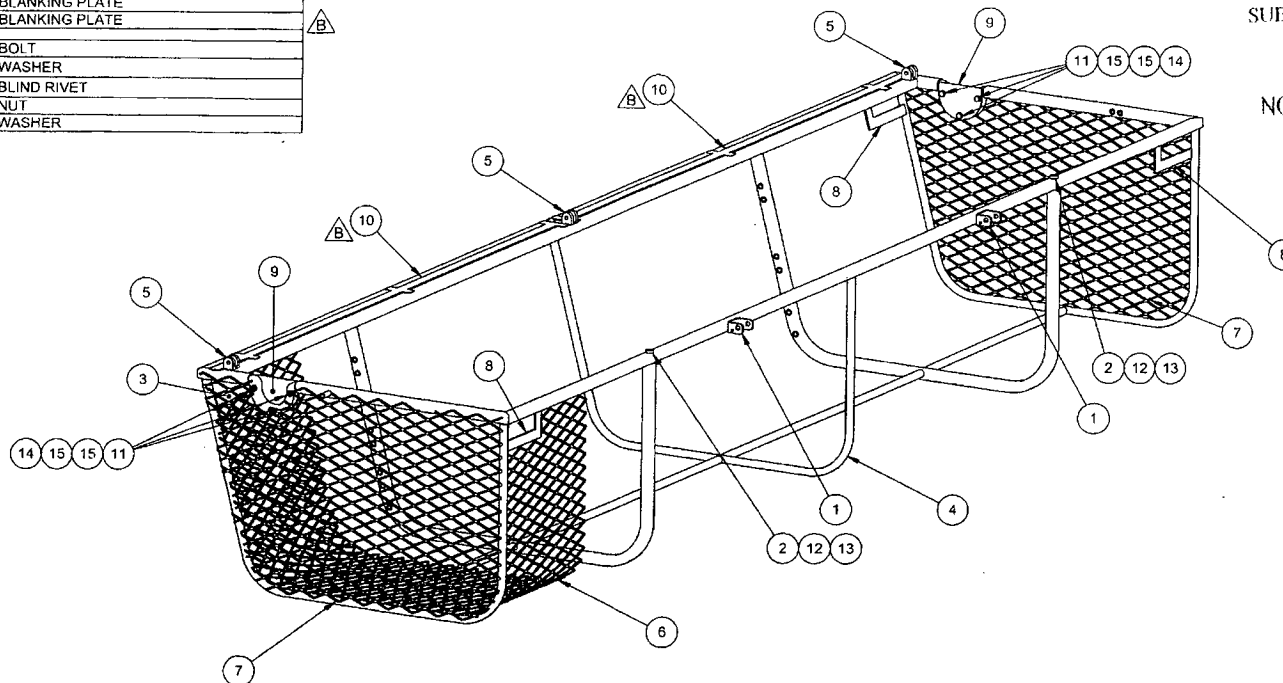
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>																								
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	AN960JD8	WASHER
13	2	MS20600AD4W3	BLIND RIVET
14	6	MS21042L3	NUT
15	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.9 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
R 2012-07-12
UP RCN 12-64

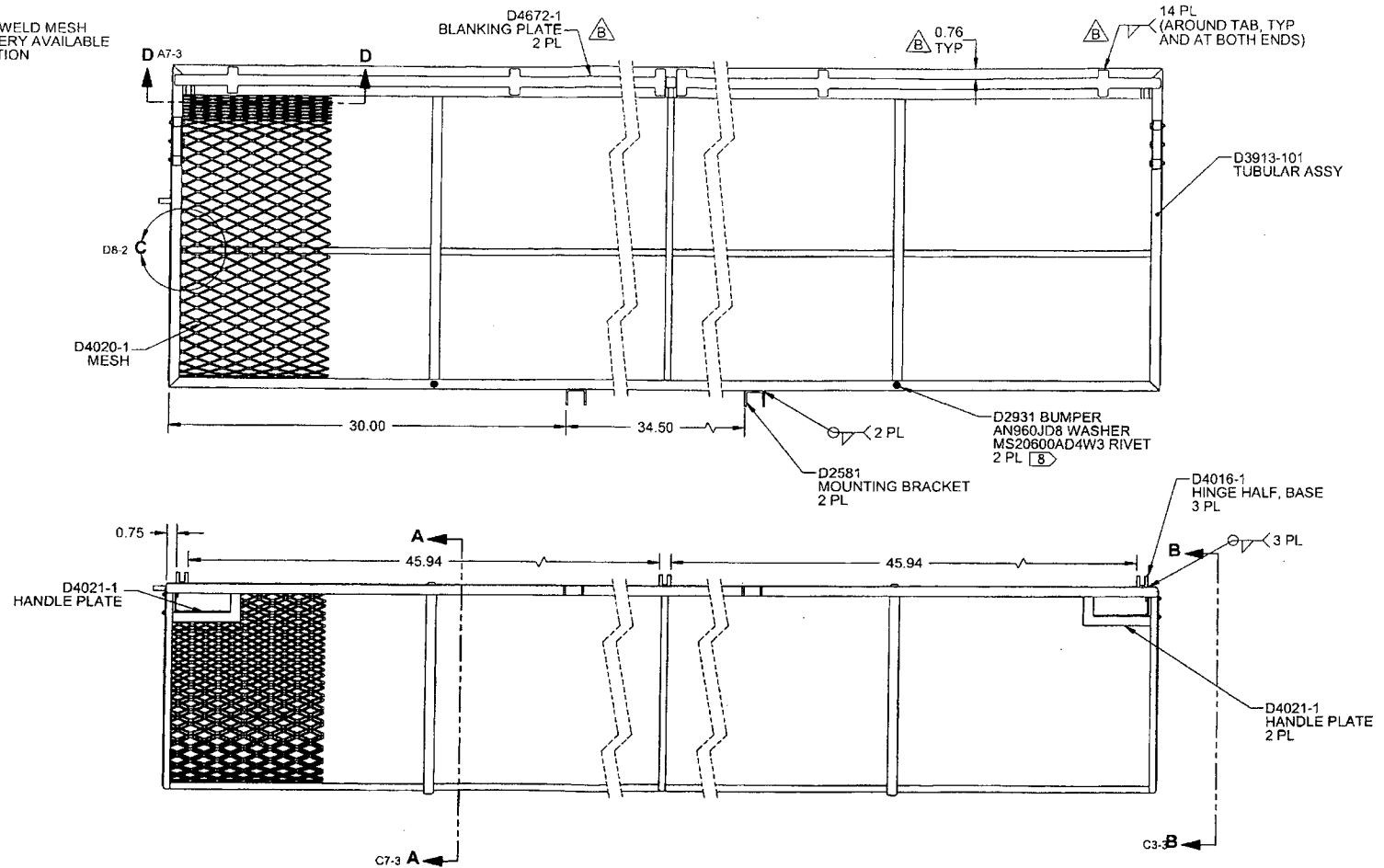
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 87587 MLJ
12/07/24

B	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2). REASON: PART2-197.	MB	12.06.15
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>AP</i>	DRAWING NO. D3913	REV. B
CHECKED	<i>AP</i>	SHEET 1 OF 6	
MFG. APPR.	<i>AP</i>	TITLE LONG BASKET BASE ASSY (350) NTS	SCALE
APPROVED	<i>AP</i>	DATE 12.06.15	
DE APPR.	<i>AP</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE SUPPLIER CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

07587

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2

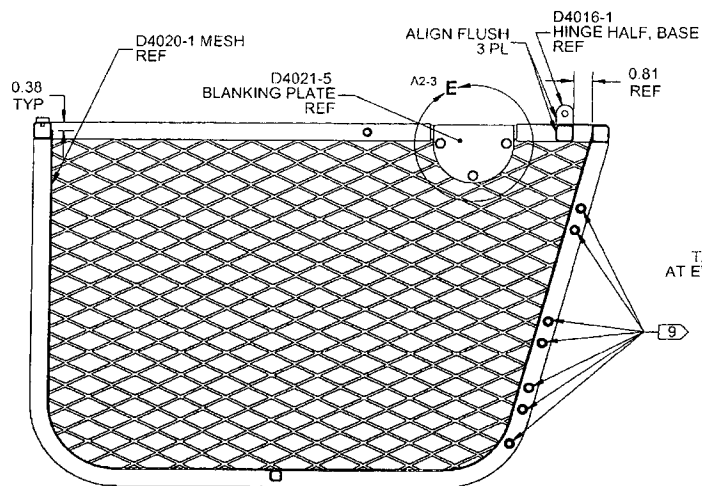


D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

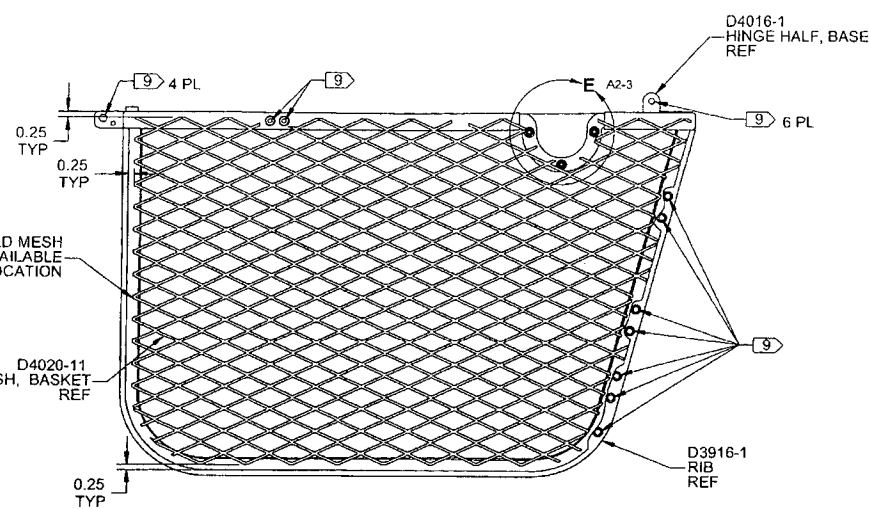
RELEASED
2012-07-12

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED	WJH	TITLE	SCALE
DE APPR.	JH	LONG BASKET BASE ASSY (350) NTS	
DATE	12.06.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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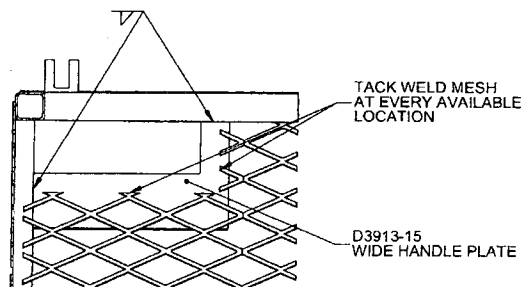
87587



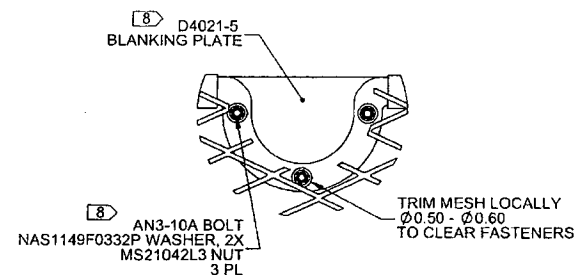
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D6-2
TYPICAL FOR ALL
HANDLE PLATES

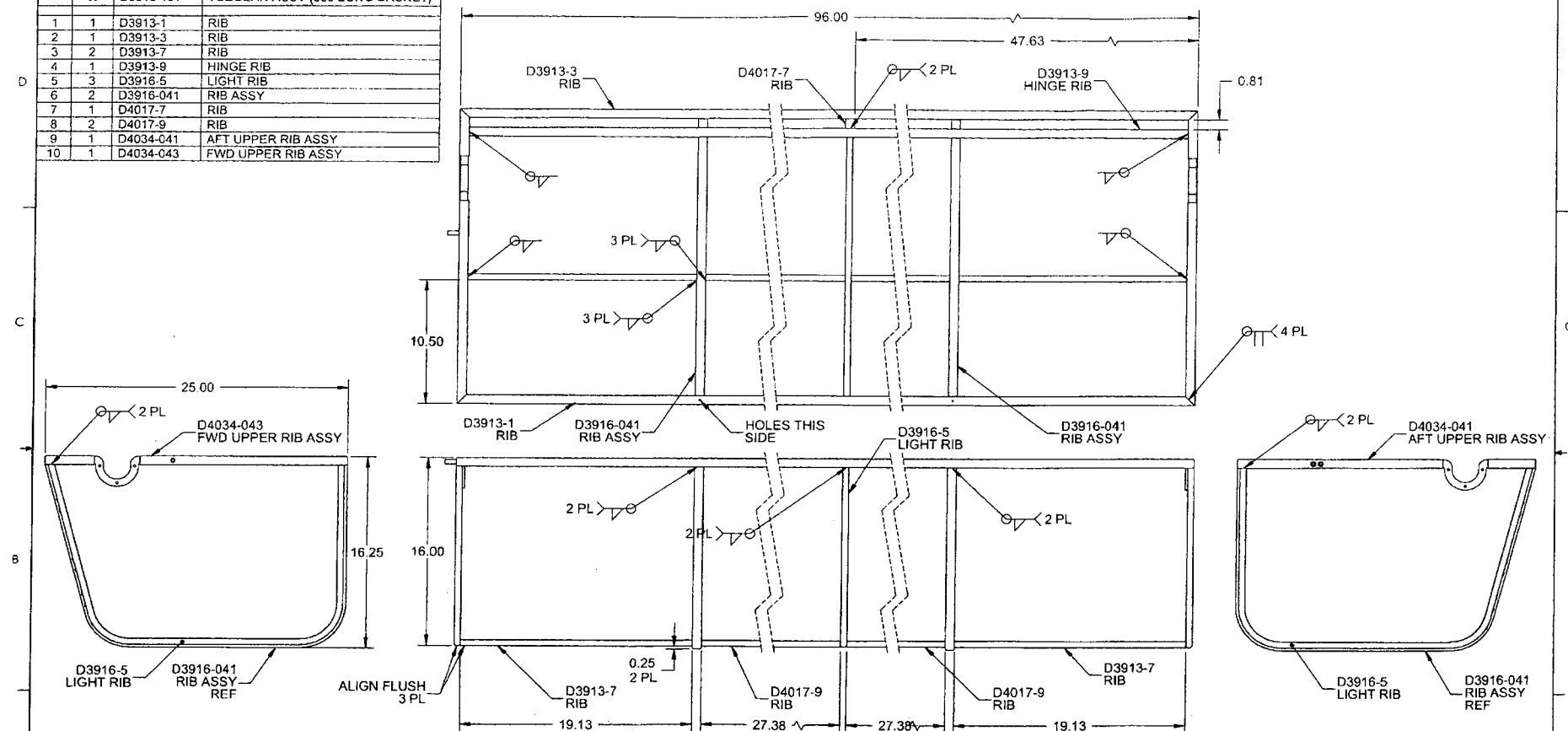


DETAIL E D2-3
D6-3

RELEASED
2012-07-12
CP

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. B
MFG. APPR.	ALS	D3913	SHEET 3 OF 6
APPROVED	ALS	TITLE	SCALE
DE APPR.	ALS	LONG BASKET BASE ASSY (350) NTS	
DATE	12.06.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

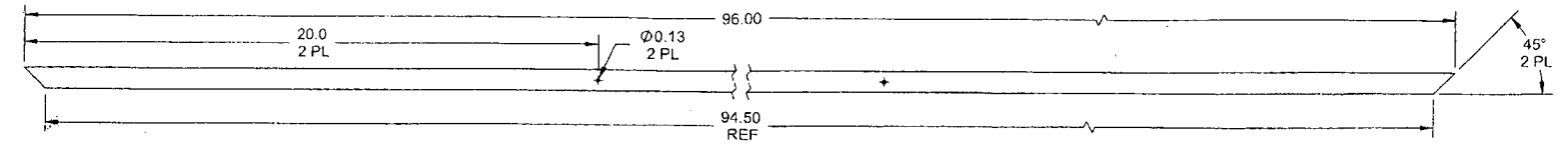
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

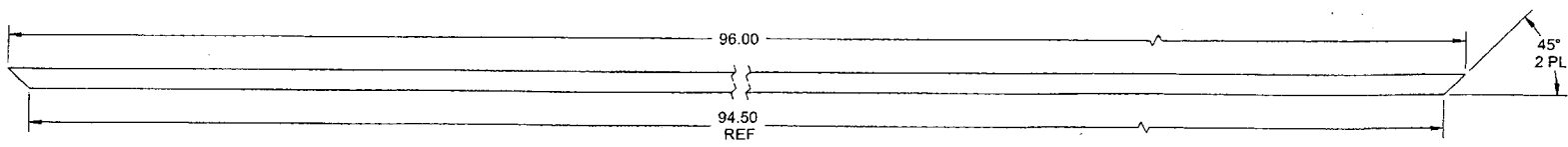
RELEASED
2012-07-12
CP

DESIGN	ALS	DART AEROSPACE LTD	REV. B
DRAWN	P.P.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	W.D.	DRAWING NO.	SHEET 4 OF 6
MFG. APPR.		D3913	
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	12.06.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE ABOVE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

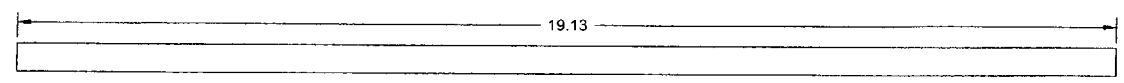
07587



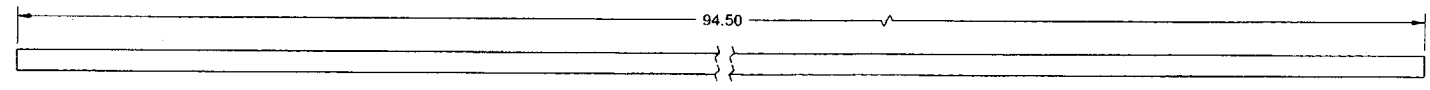
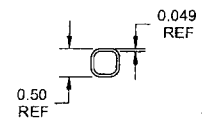
D3913-1 RIB



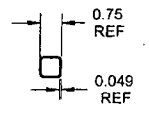
D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB



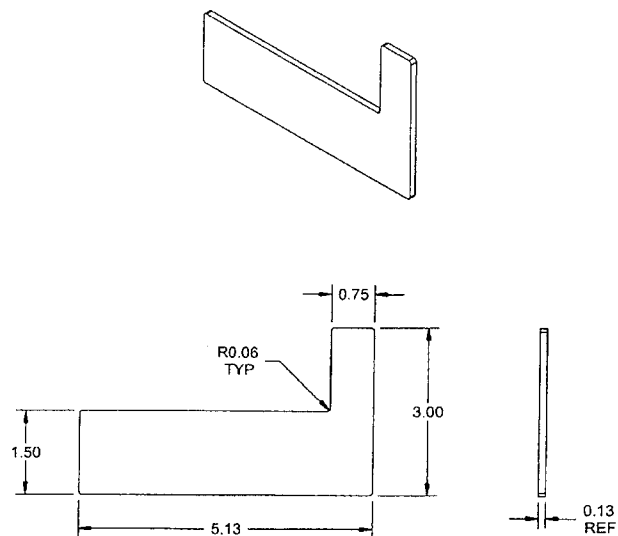
NOTES:

- 1) MATERIAL -1, -3, -9: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
2012-07-12
4P

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	J.P.	DRAWING NO. D3913	REV. B
MFG. APPR.			SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	12.06.15	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD.</small>	

87527



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

RELEASED
2012-07-12
CP

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	MP	D3913	SHEET 8 OF 8
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	LONG BASKET BASE ASSY (350) NTS	
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